

इंटरनेट

मानक

Disclosure to Promote the Right To Information

Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 413 (1974): Round Punches [PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

BLANK PAGE





AMENDMENT NO. 1 AUGUST 1982
TO
IS : 413-1974 SPECIFICATION FOR ROUND PUNCHES
(*Second Revision*)

Alteration

(*Page 1, clause 4*) — Substitute the following for the existing clause:

'4. Hardness — The punches shall have a hardness of 38 to 46 *HRC* at the free end of the punch up to a distance of 15 mm from the free end [see IS : 1586-1968 ' Method for Rockwell hardness test (B and C scales) for steel (*first revision*)] '.

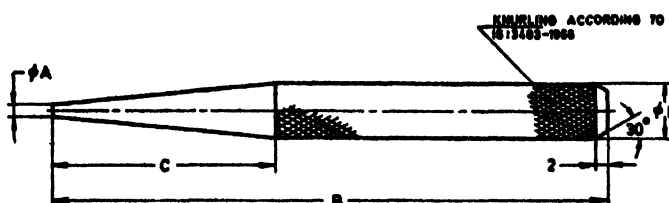


Indian Standard
SPECIFICATION FOR ROUND PUNCHES - 2002
(Second Revision)

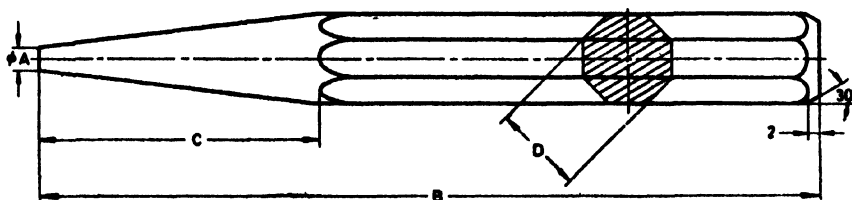
REAFFIRMED

1. Scope — Lays down the requirements for round punches for general use.

2. Dimensions



ALTERNATE SHAPE FOR SIZES 2 AND 3 ONLY



All dimensions in millimetres.

Nominal Size		B ± 5	C ± 2	D ± 1
A	Tolerance			
2	± 0.2	100	40	10
3	± 0.2	125	40	12
4	± 0.2	140	50	16
5	± 0.2	150	50	16
6	± 0.5	175	60	20
8	± 0.5	200	60	20
10	± 0.5	225	70	23
12	± 0.5	250	70	23

3. Material — Any good quality carbon or alloy tool steel meeting with the requirements laid down in 4 and 6.

Suitable Example:

T80 of IS : 3749-1966 'Specification for tool and die steels for cold work'.

4. Hardness — The punches shall have a hardness of 38 to 46 HRC at the free end of the punch up to a distance of 15 mm from the free end [see IS : 1586-1968 'Method for Rockwell hardness test (B and C scales) for steel (first revision)] .

5. Designation — A round punch of nominal size 8 mm shall be designated as:

Punch 8, IS : 413

Adopted 30 January 1974

© March 1983, ISI

Gr 1

INDIAN STANDARDS INSTITUTION
MANAK BHAVAN, 9 SAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

6. Test— The punches shall be able to punch 5 clean holes in mild steel sheet of the thickness given below with a suitable die underneath. They shall show no sign of damage or distortion on completion of the test.

Nominal Size of the Punch mm	Thickness of Mild Steel Sheet mm
2, 3, 4 and 5 6, 8, 10 and 12	1.6 4.5

7. Packing— The round punches shall be given an antirust treatment. They shall be supplied in sets in suitable steel cases. The packing shall be in accordance with the best prevalent trade practice.

8. Sampling— Unless otherwise agreed to between the buyer and the seller the procedure given in IS : 2500 (Part I)-1963 'Sampling inspection tables: Part I inspection by attributes and by count of defects', may be followed for sampling inspection. The sampling plans for various characteristics shall be according to 8.1 and 8.2.

8.1 For inspection of dimensions, single sampling plan with inspection level III and acceptable quality level (AQL) of 2.5 percent [see Tables 1 and 2 of IS : 2500 (Part I)-1963] shall be adopted.

8.2 For inspection of hardness and test, single sampling plan with inspection level I and acceptable quality level (AQL) of 1.0 percent [see Tables 1 and 2 of IS : 2500 (Part I)-1963] shall be adopted.

9. Marking— Round punches shall be marked with the nominal size, manufacturer's name, initials or recognized trade-mark. The containers of the punches shall also be marked with the description of the contents. In case of small punches where it may not be possible to mark the punch itself, only the container shall be marked with the description of the contents.

9.1 ISI Certification Marking— Details available with the Indian Standards Institution.

EXPLANATORY NOTE

This standard deals with round punches for cold punching of holes in sheet metal. This standard was originally issued in 1953 and was revised in 1965 so as to include: (a) Dimensional requirement in metric system, and (b) Sampling plan and criteria for conformity.

The present revision has been taken up to bring the standard in line with the current manufacturing practices and provision has been made that the punches of nominal sizes 2 and 3 mm may be manufactured from round sections as well.